DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-014953
Date Inspected: 18-Jun-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1700
Location: Shanghai, China

CWI Name:	An Qing Xiang.			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☐ No	☑ N/A

Bridge No: 34-0006
Component: Tower

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY 11: SMAW Process
This QA Inspector observed ZPMC qualified welding personnel identified as 046769, Perform Shielded Metal Arc Welding (SMAW) on Tower strut. Joint identified as SD1-STSA4-5-143M-1-17, 18, 25, 26, ZPMC CWI Identified as Yu Dong Ping, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2112.

SMAW Process, Repair Welding.
This QA Inspector observed ZPMC qualified welding personnel identified as 044541, Perform Shielded Metal Arc Welding (SMAW) on Tower strut. Joint identified as ED1-STSA4-10-119M-1-35A/B, ZPMC QC Identified as Mao Bin Bin, with temporary welding repair report WRR-T-WR3312. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-2G (2F)-FCM-Repair-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040619, 046704, Perform Shielded Metal Arc Welding (SMAW) on West tower lift 5 Grillage plate. Joint identified as WSD1-TL5-4B/F-11A/B.

ZPMC QC Identified as Mao Bin Bin, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-B-U3b.

This QA Inspector observed ZPMC qualified welding personnel identified as 046709, Perform Shielded Metal Arc Welding (SMAW) on Interior splice plate. Joint identified as ESD1-SPSA5-7-3B, 1B. ZPMC QC Identified as Liu Dao Feng, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3211-Tc-U5b-1.

Repair Welding: FCAW Process.
This QA Inspector observed ZPMC qualified welding personnel identified as 040759, 040723, Perform Flux Core Arc Welding (FCAW) on Grillage Top plate. Joint identified as GTSA5-B/G-3A/B, 6A/B. ZPMC QC Identified as Xu Jun Long, with Temporary welding repair report WRR-T-WR3367 and 3368. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-1G (1F)-Repair.

Repair Welding: SMAW Process.
This QA Inspector observed ZPMC qualified welding personnel identified as 040724, 251194, 044551, 040611, Perform Shielded Metal Arc Welding (SMAW) on East, West tower lift 5 Transverse Diaphragm plate. Plate identified as LD5-4, weld Build up required 27mm, ZPMC CWI Identified as Yu Dong Ping, with Critical welding repair report CWR-T-CWR637. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-2G (2F)-Repair-1.

BAY 10: SMAW Process:
This QA Inspector observed ZPMC qualified welding personnel identified as 044511, Perform Shielded Metal Arc Welding (SMAW) on Interior splice plate. Joint identified as NSD1-SPSA5-6-3B, ZPMC QC Identified as Lijun, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3211-Tc-U5b-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 050289, Perform Shielded Metal Arc Welding (SMAW) on Interior splice plate. Joint identified as NSD1-SPSA5-1-1A. ZPMC QC Identified as Lijun, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3211-Tc-U5b-1. For more information see below attach photo number 1.

This QA Inspector observed ZPMC qualified welding personnel identified as 050266, Perform Shielded Metal Arc Welding (SMAW) on Interior splice plate. Joint identified as SSD1-SPSA5-6-3B, ZPMC QC Identified as Lijun, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3211-Tc-U5b-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 057258, Perform Shielded Metal Arc Welding (SMAW) on Interior splice plate. Joint identified as NSD1-SPSA5-16-3A. ZPMC QC Identified as Lijun, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3211-Tc-U5b-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 052930, 052493, Perform Shielded

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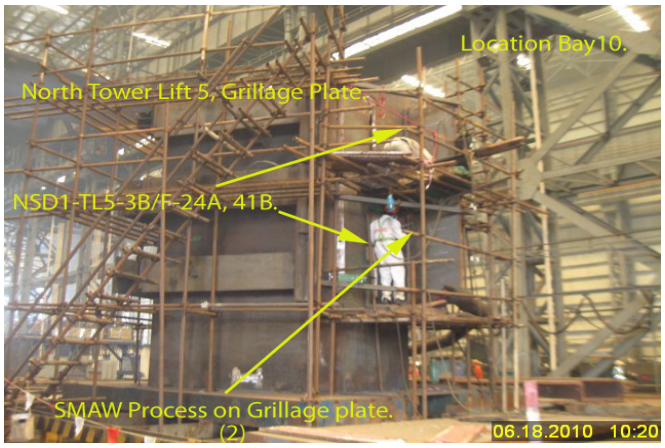
Metal Arc Welding (SMAW) on North tower lift 5 Grillage plate. Joint identified as NSD1-TL5-3B/F-24A, 41B. ZPMC QC Identified as Li Peng Fei, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-B-U3b. For more information see below attach photo number 2.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng Phone: 15921845703, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Shailesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer